

Work Order ID 132702-2

132702

Page 1

Thursday, May 07, 2015 2:55:31 PM

Item ID: D3537-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/7/2015 Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: CY Date: MAR 08 2015

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	D

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut D3537-3 as per Dwg D3537

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

(44) 05/05/12

(44) 05/05/12

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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Work Order ID 132702

Thursday, May 07, 2015 2:55:31 PM

132702

Page 2

Item ID: D3537-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 5/7/2015

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

MAY 14 2015

130

Form as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

44X

DAS
38
9-89
15/05/14

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

44

DAS
38
9-89
MAY 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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				Lead hand / Supervisor Approval Verification.																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

Work Order ID 132702

Thursday, May 07, 2015 2:55:31 PM

132702

Page 3

Item ID: D3537-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/7/2015

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Hardcoat S.S. Batch: _____

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

A/R 2059B Hardcoat BATCH: _____

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

SCRAP

use for testing on Robot

DAS
9
9-89

1509-16

20
15-9-16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
948322 SCRAP				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 132702

Thursday, May 07, 2015 2:55:31 PM

132702

Page 4

Item ID: D3537-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 5/7/2015 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
200									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

Dis-a-16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 1

Thursday, May 07, 2015 2:55:30 PM

Work Order ID: 132702

132702

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	318.7176	0.149	6.273684			
M304S16GA									**	<u>8.6</u>		<u>05/05/13</u>	
304/316 Sheet .063													

Location

MAT019

Loc Qty

318.7176

Loc Code

m131384

121.4176

m131503

197.3

6.6

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

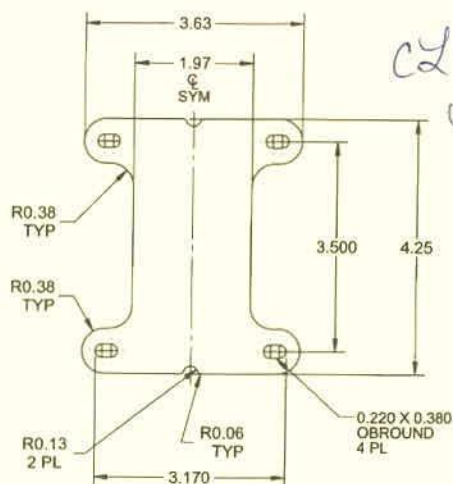
QA Closed: _____ Date: _____

Work Order update only ☐

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D3537-1 WEARPAD
(MAKE FROM D3537-1F)

0.25
TYP



D3537-1F FLAT PATTERN

NOTES:

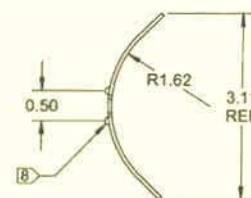
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004

C2 MAR 08 2015
WID: 132702

D3537-5 WEARPAD
(MAKE FROM D3537-1F)

NOTES:

- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



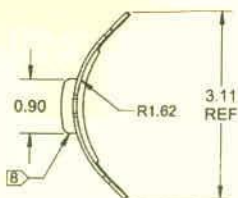
D3537-9 WEARPAD
(MAKE FROM D3537-1F)

NOTES:

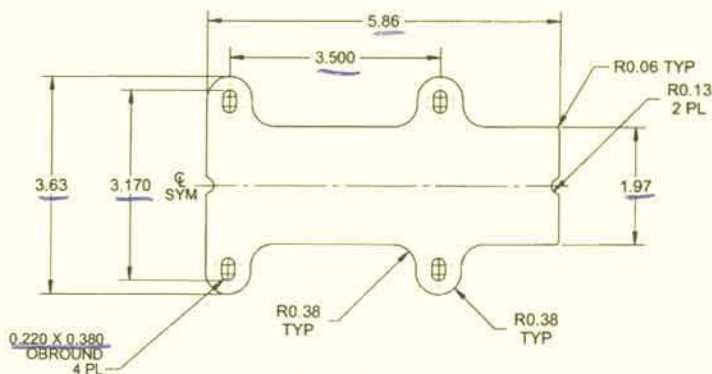
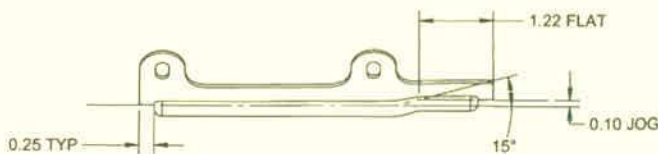
- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.19 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06
REV	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG APPR	DD	D3537	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR	D3	WEARPAD	NTS
DATE	14.10.16	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2014-11-05



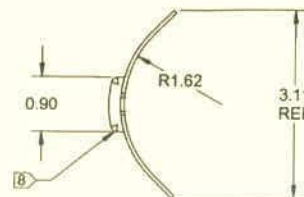
D3537-3 WEARPAD
(MAKE FROM D3537-3F)



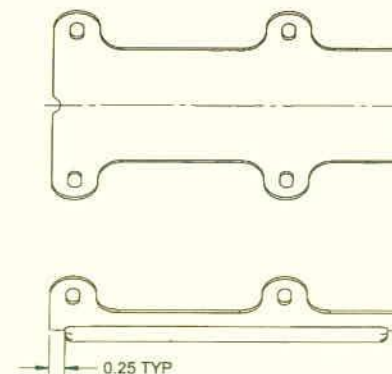
D3537-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004

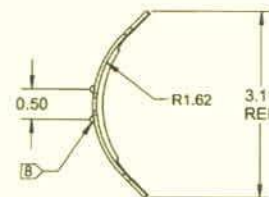


D3537-7 WEARPAD
(MAKE FROM D3537-3F)

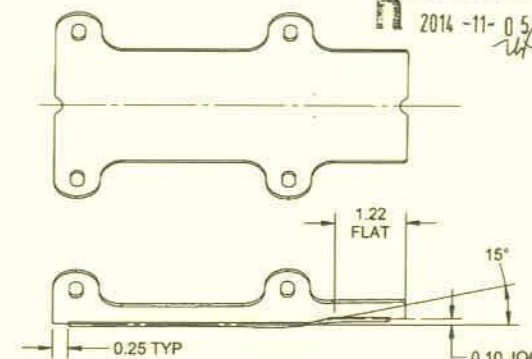


NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-11 WEARPAD
(MAKE FROM D3537-3F)



NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.25 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
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2014-11-05

FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD	Work Order:	132702
Description: wear pad	Part Number:	3537-3
Inspection Dwg: 3537	Rev: D	Page 1 of 1